

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000158**Date Inspected:** 03-May-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

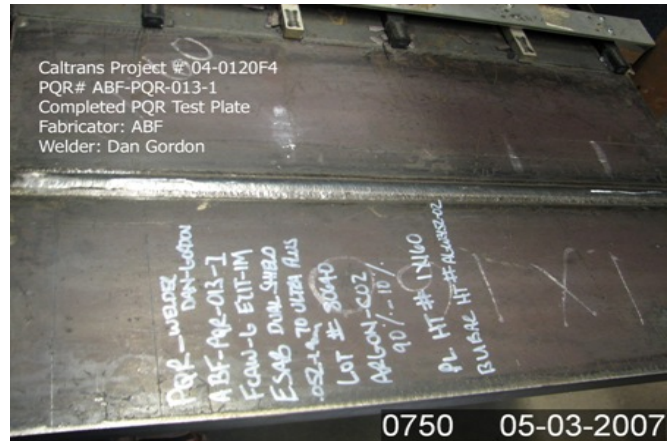
Caltrans Quality Assurance (QA) Inspector Mary Madere is present at the Ironworkers Apprenticeship Training Facility as requested by ABF for the continuing purpose of witnessing Procedure Qualification Record tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Company's Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representative Mr. Tommy Gibson, and welder Mr. Dan Gordon.

The QA Inspector observed Quality Control (QC) Representative Mr. Michael Johnson as he performed ultrasonic testing (UT) of the Procedure Qualification Record (PQR) Test Plate identified as ABF-PQR-013-1. See summary of conversations below for additional information.

The QA Inspector observed welder Dan Gordon preparing a test plate for the next PQR to be welded. Mr. Gordon used a grinder to remove loose scale from each plate on each side of the plate, including the bevel. No PQR welding was performed on this date. Under the direction of ABF Representative Mr. Tommy Gibson, Mr. Gordon welded the root pass of practice test plates in preparation for the next PQR test plate. Mr. Gibson then cut sections from the practice test plates to assist in determining the quality of the root pass welded by Mr. Gordon. See the following digital photographs for additional information.

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Summary of Conversations:

Quality Control Representative Mr. Michael Johnson stated that the informational Ultrasonic Test (UT) of the Procedure Qualification Record (PQR) Test plate identified as ABF-PQR-013-1 revealed indications in the root area. After sizing these indications, Mr. Johnson stated that the indication ratings ranged from +14 to +20 dbs.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Madere, Mary

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer